



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-558-041
Job Sheet 180705



Part No: D206-558-041

Job Qty: 1 ea

Part Name: Single Mirror Installation



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 7/25/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D SHEET 13 IPP F 02.09.19 Re-format; Incorporated D2065 KJ IPP Rev:G 08-05-14 now @ chg006/ add D3778-1 per ECN1171 DD verified:ec IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec IPP Rev:I 10.03.17 add pick kit DD verified by:JLM IPP REV:J 11.01.19 AS PER CHG009 DD VERF:EC IPP REV:K 14.09.09 AS PER IIN REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/25/18	7/25/18	0.00	0.00	Start Up Small Fab-4		JUL 20 2018
110	Small Fab	1 pcs	7/25/18	7/25/18	0.00	0.71	Small Fab-1		DAS 38
120	QC	1 pcs	7/25/18	7/25/18	0.00	0.00	QC5		JUL 30 2018
125	Packaging	1 pcs	7/25/18	7/25/18	0.00	0.00	Packaging1-2		JUL 30 2018
130	QC	1 pcs	7/25/18	7/25/18	0.00	0.00	QC4		JAB 28
135	DC	1 pcs	7/25/18	7/25/18	0.00	0.00	DC		JAB 28
140	Packaging	1 pcs	7/25/18	7/25/18	0.00	0.00	Packaging3-1		9-89
150	QC21-FG	1 Ea	7/25/18	7/25/18	0.00	0.00	QC21		

Part Op 110 - Assemble as per Dwg D206-558 PAGE 10 IN BLUE FILE
Descriptions: 135 - Photocopy bluefile and type labels as per PPP D206-558-041 CHG009
140 - Identify and pack for shipping as per PPP D206-558-041



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S096985



Part: D206-558-041

Job No: 180705

Serial No/Batch: S096985

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-17 Issue 7 FAA-STD SH1031N

DAS
53
9-89

JUL 30 2018

Fgo!

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER :					

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2011-101	Mirror 6"	1 Ea (1 ea)	90-Start up Operation	5083123
D2052	Bracket	2 Ea (2 ea)	90-Start up Operation	F162630 1X F165648 1X
D2054	Bushing - Delrin	2 Ea (2 ea)	90-Start up Operation	5031100
D2055	Clamp	1 Ea (1 ea)	90-Start up Operation	5084937
D2056	Bell Crank Assembly	1 Ea (1 ea)	90-Start up Operation	F161797
D2057	Plug	1 Ea (1 ea)	90-Start up Operation	5030905
D2065	Mirror Arm	1 Ea (1 ea)	90-Start up Operation	F165518
MS21042L3	Nut	2 Ea (2 ea)	90-Start up Operation	508167
MS27039-1-18	Screw	2 Ea (2 ea)	90-Start up Operation	F124326
NAS1149D0363J	Washer	4 Ea (4 ea)	90-Start up Operation	5015265
AN3-4A	Bolt	4 Ea (4 ea)	125-Packaging	5060062
AN526-1032R9	Screw	4 Ea (4 ea)	125-Packaging	FM137776-4
D2053	Bracket	1 Ea (1 ea)	125-Packaging	5027177
D2067	Connector	1 Ea (1 ea)	125-Packaging	5097101
D2071	Cable Assembly - 32"	1 Ea (1 ea)	125-Packaging	5072096
D3778-1	Bracket	1 Ea (1 ea)	125-Packaging	F158002
MS21042L3	Nut	1 Ea (1 ea)	125-Packaging	5078107
MS21919-DG5	Clamp	2 Ea (2 ea)	125-Packaging	5083552
MS35489-67	Grommet	1 Ea (1 ea)	125-Packaging	FM121600
MS35489-9	Grommet	1 Ea (1 ea)	125-Packaging	FM136044
NAS1149D0332J	Washer	6 Ea (6 ea)	125-Packaging	5035396

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2011-101	1	30	0
	D2052	2	19	0
	D2054	2	21	0
	D2055	1	0	0
	D2056	1	14	0
	D2057	1	18	0
	D2065	1	2	0
	MS21042L3	2	1,920	0
	MS27039-1-18	2	1,260	0
	NAS1149D0363J	4	1,444	0
	AN3-4A	4	265	0
	AN526-1032R9	4	64	0
	D2053	1	5	0
125-Packaging	D2067	1	0	0
	D2071	1	14	0
	D3778-1	1	5	0
	MS21042L3	1	1,920	0
	MS21919-DG5	2	48	0
	MS35489-67	1	30	0
	MS35489-9	1	33	0
	NAS1149D0332J	6	1,499	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

REFERENCE ONLY

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 206A/B/L/L1/L3/L4	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D206-558-043	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 206A/B/L/L1/L3/L4	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg
D407-558-045	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 407	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D407-558-047	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 407	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg

5.0 PARTS LIST

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X			D206-558-043	DUAL CARGO MIRROR ASSEMBLY
		X		D407-558-045	SINGLE CARGO MIRROR ASSEMBLY
			X	D407-558-047	DUAL CARGO MIRROR ASSEMBLY
1	2	1	2	D2011-101	MIRROR ASSEMBLY
2	2	2	2	D2052**	BRACKET
1	1	1	1	D2053	BRACKET
2	2	2	2	D2054**	BUSHING
1	1	1	1	D2055**	CLAMP
1	1	1	1	D2056**	BELLCRANK ASSEMBLY
1		1		D2057	PLUG
1		1		D2065	ARM
	1		1	D2066	ARM
1	1	1	1	D2067	CONNECTOR
1	1			D2071	CABLE ASSEMBLY
		1	1	D2071-5	CABLE ASSEMBLY
1	2	1	2	D3014-1*	LOCKNUT
1	1			D3778-1	BRACKET
		1	1	D3778-3	BRACKET
4	4	4	4	AN3-4A	BOLT
4	4	4	4	AN526-1032R9	SCREW
1	2	1	2	NAS1149D0416P*	WASHER (AN960JD416L)
4	4	4	4	NAS1149D0363P**	WASHER (AN960JD10)
6	6	6	6	NAS1149D0332P	WASHER (AN960JD10L)
3	1	3	1	MS21042-3	NUT (or MS21042L3)
	2		2	MS21042-3**	NUT (or MS21042L3)
2	2	2	2	MS21919DG5	CLAMP
2	2	2	2	MS27039-1-18**	SCREW
1	1	1	1	MS35489-9	GROMMET
1	1	1	1	MS35489-67	GROMMET

* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

** INCLUDED AS PART OF D2066 ARM (REF. -043/-047 ONLY)

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Revision: D

Date: 14.08.08

REFERENCE ONLY